

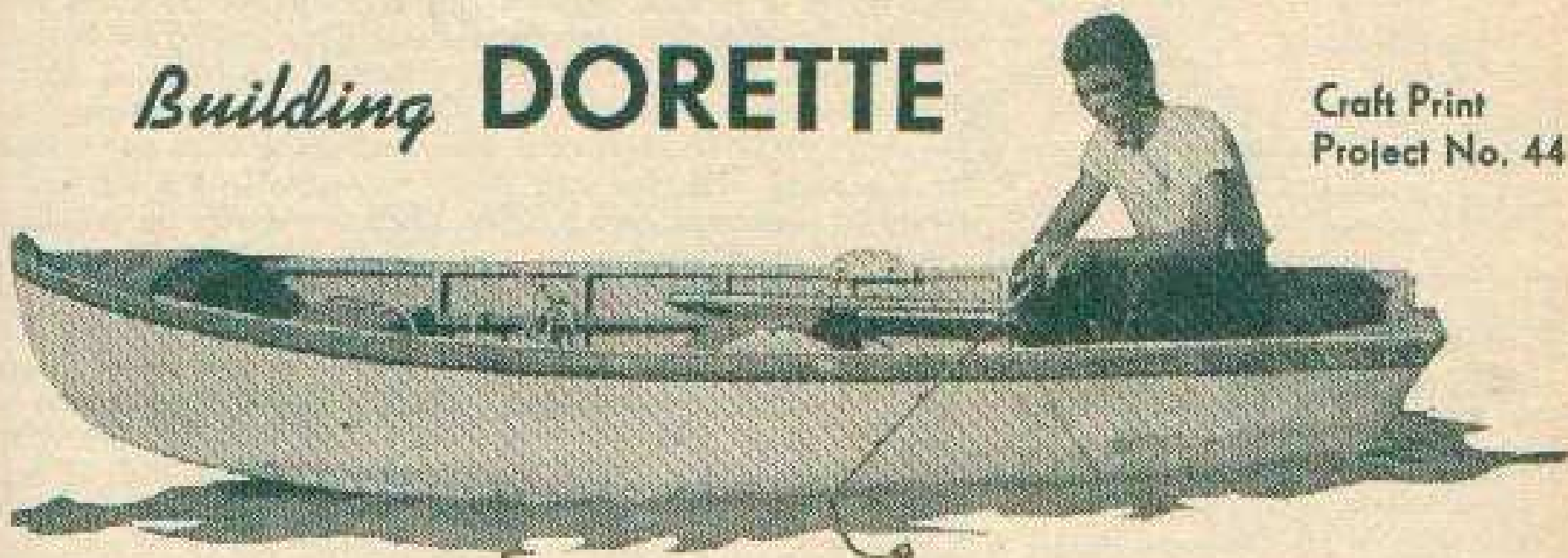
Use two coats of flat white, then a good water-proof enamel.

The craft can be made steadier in the water by taking the inner tube from an auto tire and attaching it around the edge of the boat with

fishline. Do not place the tube at the top edge; instead, place it approximately halfway up the side where its buoyancy will keep the boat from tipping over on its side when the waves strike it. —N.B.

Building DORETTE

Craft Print
Project No. 44



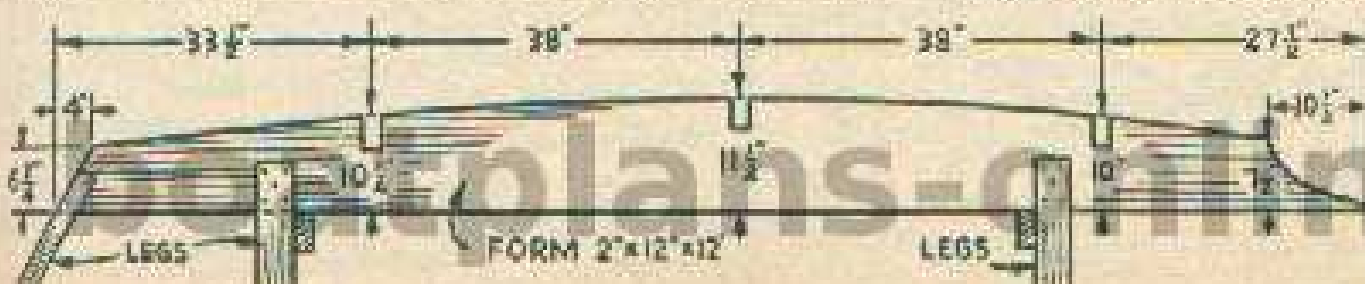
Meet a versatile, lightweight, V-bottom skiff designed for 1-5 hp motors

By W. D. JACKSON

DORETTE is an easily-built, V-bottom skiff that is light in weight (about 150 lb.), strong, and eminently seaworthy on most any waters. It may be powered with outboard motors of 1 to 5 hp for speeds of 1 to 12 mph. It rides easily, carrying two passengers in rough waters and an additional pair on smooth water.

Dorette can be powered with air-cooled inboards, used as a rowboat, or fitted with a sail. If you want to build in quantity and sell for a profit, you'll find Dorette is easy to build, sturdy, and the same forms used in building one can be used for a hundred boats.

To build Dorette, first prepare the building forms (such as mold frames and form). If more than one boat is to be built, make these frames quite strong with additional bracing to prevent misalignment in future Dorettes. Saw form to shape as shown and mount upon legs similar to a saw horse at a convenient working height. Mold frames #1, #2, and #3 are next sawed to shape from 2x4's



LIST OF MATERIALS

Lumber Required

Chines	2 pcs.	3/4" x 1 3/4" x 14'
Clamps	2 pcs.	3/4" x 1 1/2" x 14'
Keel (inner)	1 pc.	3/4" x 3 3/4" x 12'
Keel (outer)	1 pc.	3/4" x 2" x 12'
Seat risers	1 pc.	3/4" x 2" x 12'
Moldings	4 pcs. (oak)	3/4" x 1 1/4" x 14'
Rub strips	2 pcs.	1/2" x 3/4" x 12'
Ribs	3 pcs.	3/4" x 1 1/4" x 15'
Stem	1 pc.	1 3/4" x 10" x 36"
Outer stem piece	1 pc.	5/8" x 1 3/4" x 36"
Transom knees and breast hook	1 pc.	1 1/2" x 10" x 24"
Transom frame	1 pc.	3/4" x 3" x 8"
	1 pc.	3/4" x 6" x 4"
Seats	1 pc.	3/4" x 11 3/4" x 16'
Form	1 pc.	2" x 12" x 12"
Mold frames	2 pcs.	2" x 4" x 12" } Lumber measure

Plywood Required

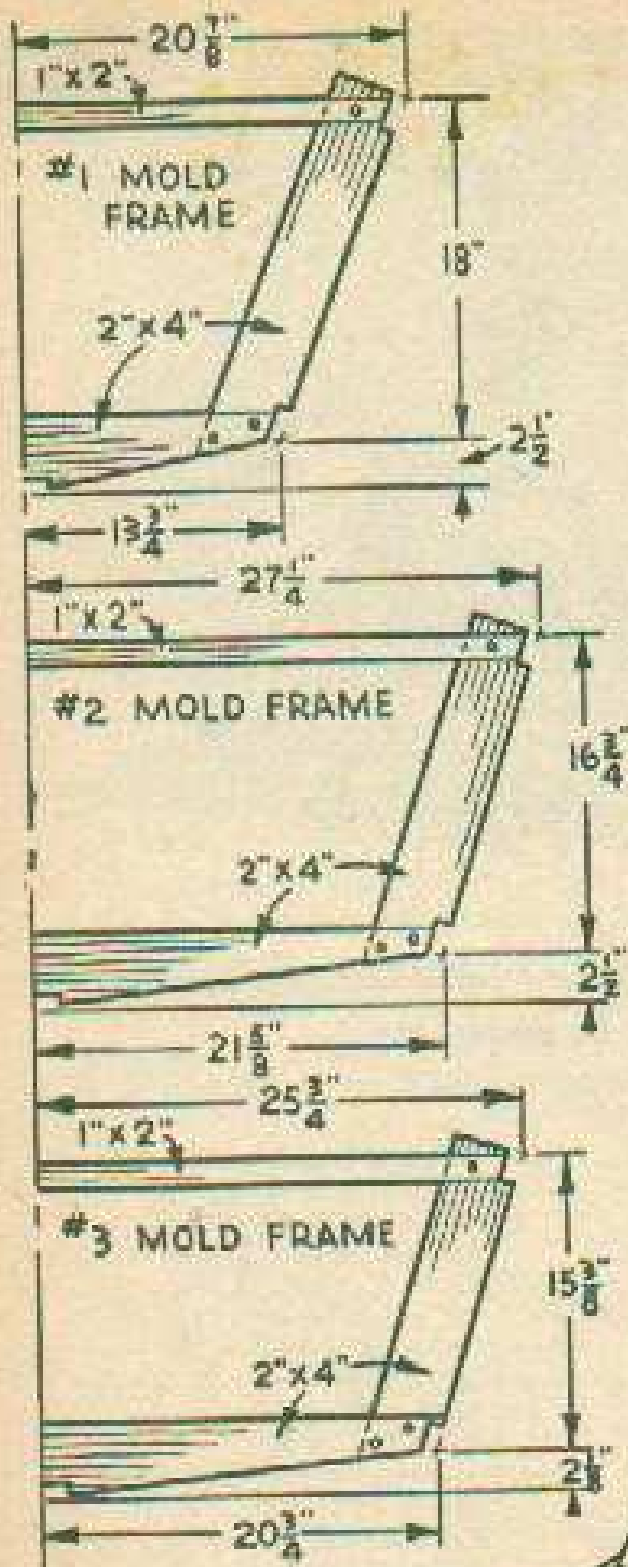
Sides	1 pc.	5/16" or 3/8" x 4' x 14'
Bottom	1 pc.	3/8" x 4' x 12'
Floor boards	1 pc.	1/2" x 4' x 8'
Transom	1 pc.	3/8" x 24" x 48"

Fastenings Required

6 gross	1" No. 8 flathead screws
3 doz.	1 1/2" No. 8 flathead screws
3 doz.	2" No. 10 flathead screws
1 lb.	galvanized shingle nails, 1 1/4"
1 lb.	resin glue (Weldwood, Cascophen or Ferdinand's)

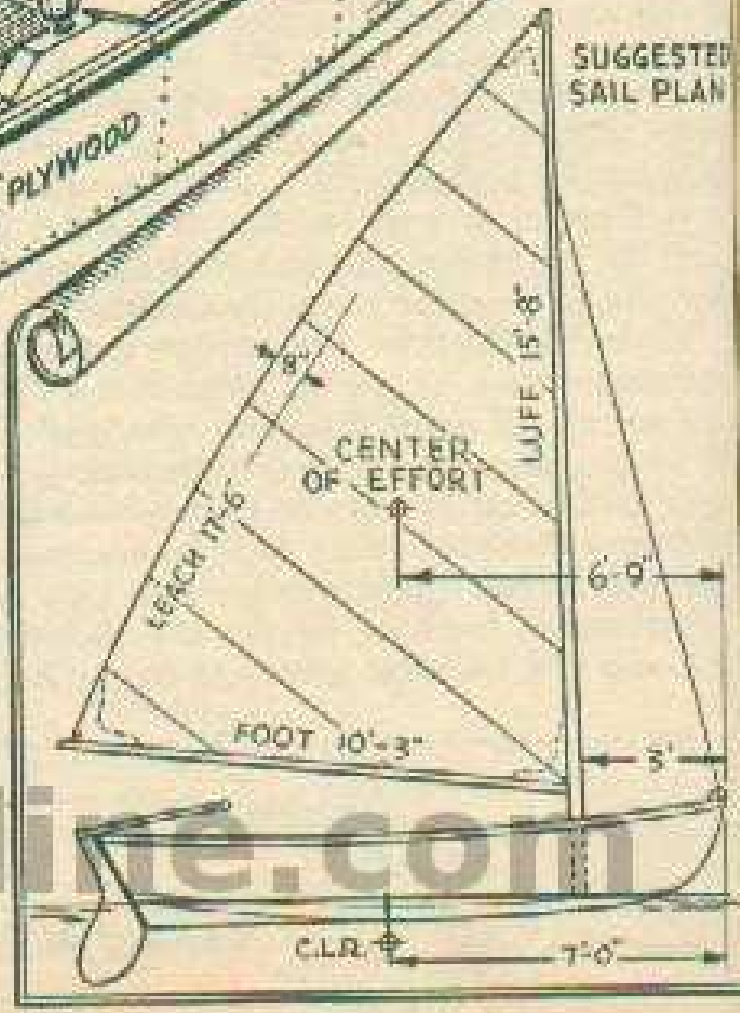
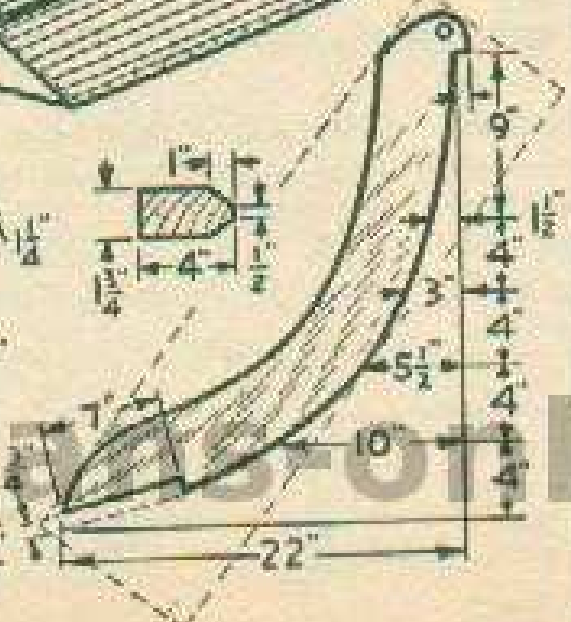
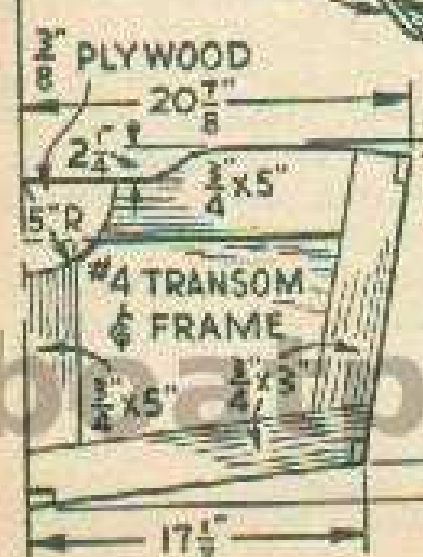
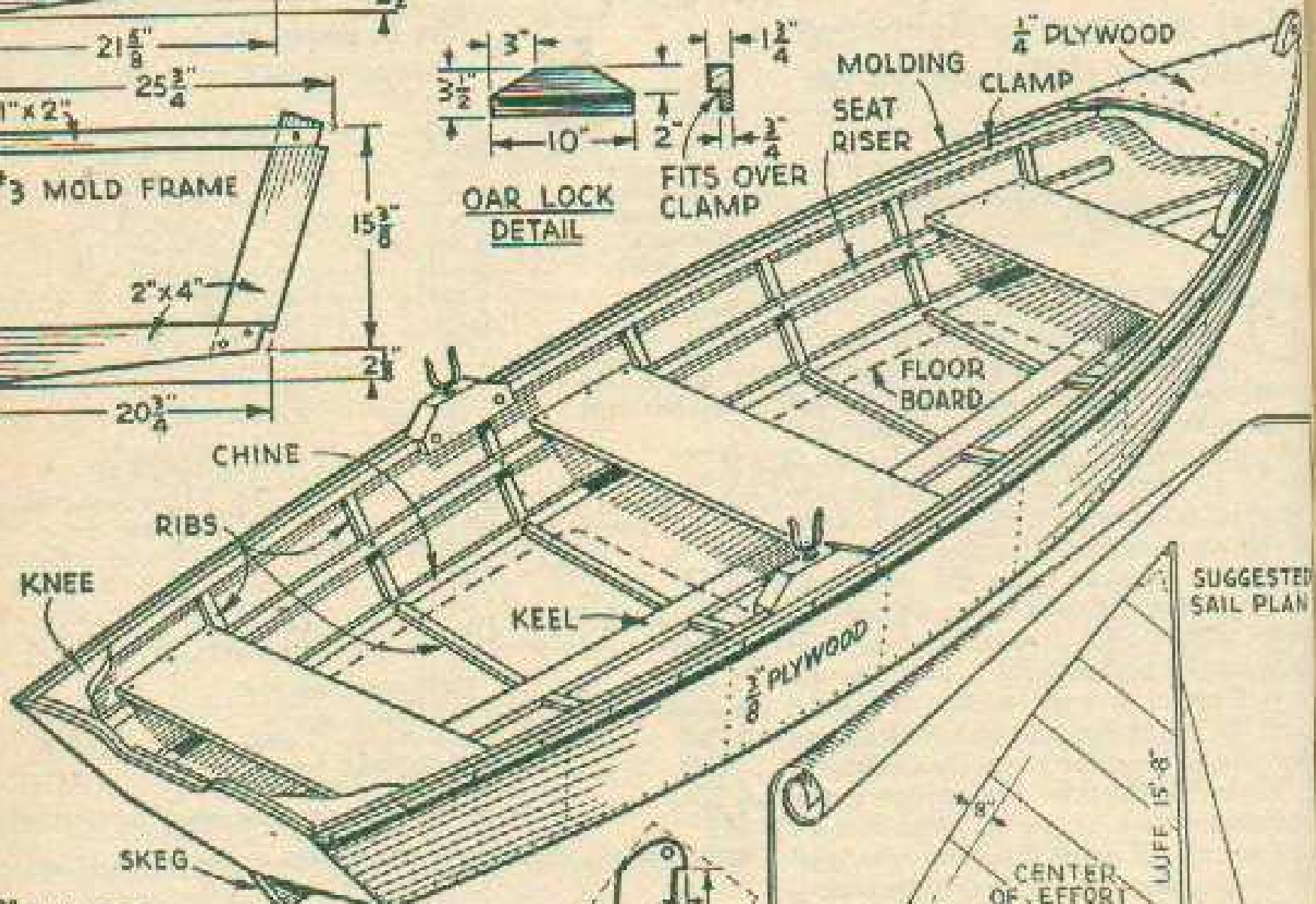
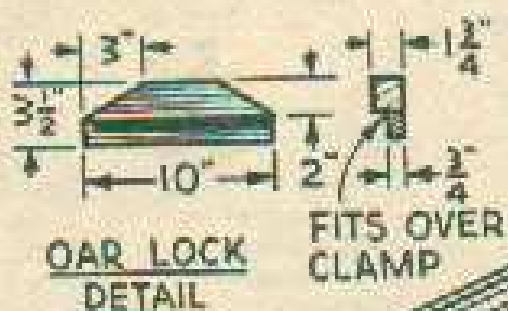
and braced as shown. As one half of the frame only is shown upon the plans, draw two sides of the frame alike. Make full size drawings on large sheets of building paper. Lay 2x4 frame material on the outlines, mark, and cut to shape.

Notch mold frames for keel, chines, and clamps, and then notch form to receive mold frames. Next fasten mold frames in place upon form. Square molds with form



and brace where necessary. These mold frames and form are not permanent parts of the boat but when the boat is planked, the hull can be lifted clear of form and another boat started, if you are mass producing them.

Transom and frame and stem are next sawed to shape. The transom is of 3/8 inch plywood and frame is secured to it as indicated, by gluing in place with resin glue and screw-fastening with 1 inch #8 flathead screws. Screws are inserted through plywood side of transom. The stem is next sawed to shape and beveled. Next notch for the keel, and place stem and transom on the form. We are now ready to assemble the framework. Begin by placing keel in position and screw-fastening to transom notch and stem notch with two 2 inch #10 flathead screws to each member. Don't fasten any members permanently to form or mold frames as this would prevent lifting the boat free after it is completed. But for members such as the chines, secure them to molds temporarily with small angle irons, screw fastened to molds and chines on the inside corners. When hull is planked, remove screws in angle irons and lift hull off form. Continue by springing both chines in place simultaneously, fastening at transom notch with 2 inch #10 flathead screws. Continue forward and bevel chine ends to fit sides of stem and fasten similarly. The clamps are next sprung in place and



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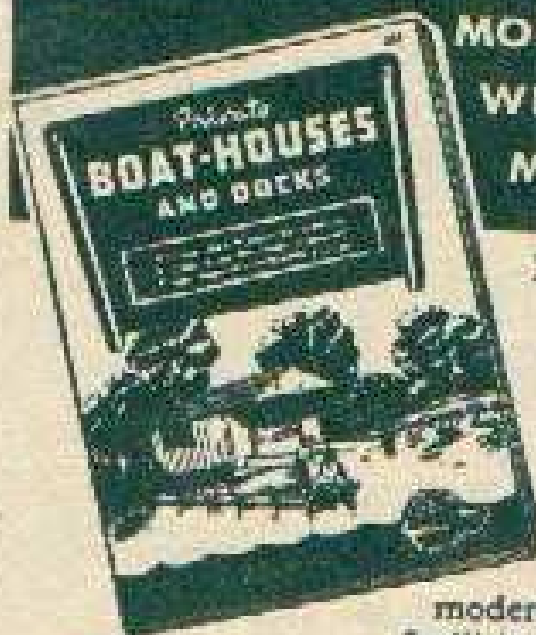
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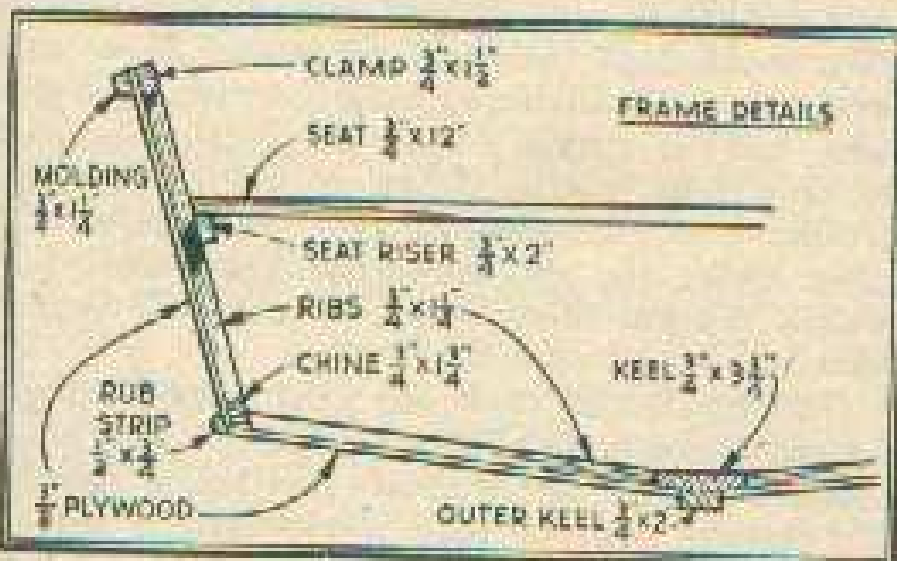
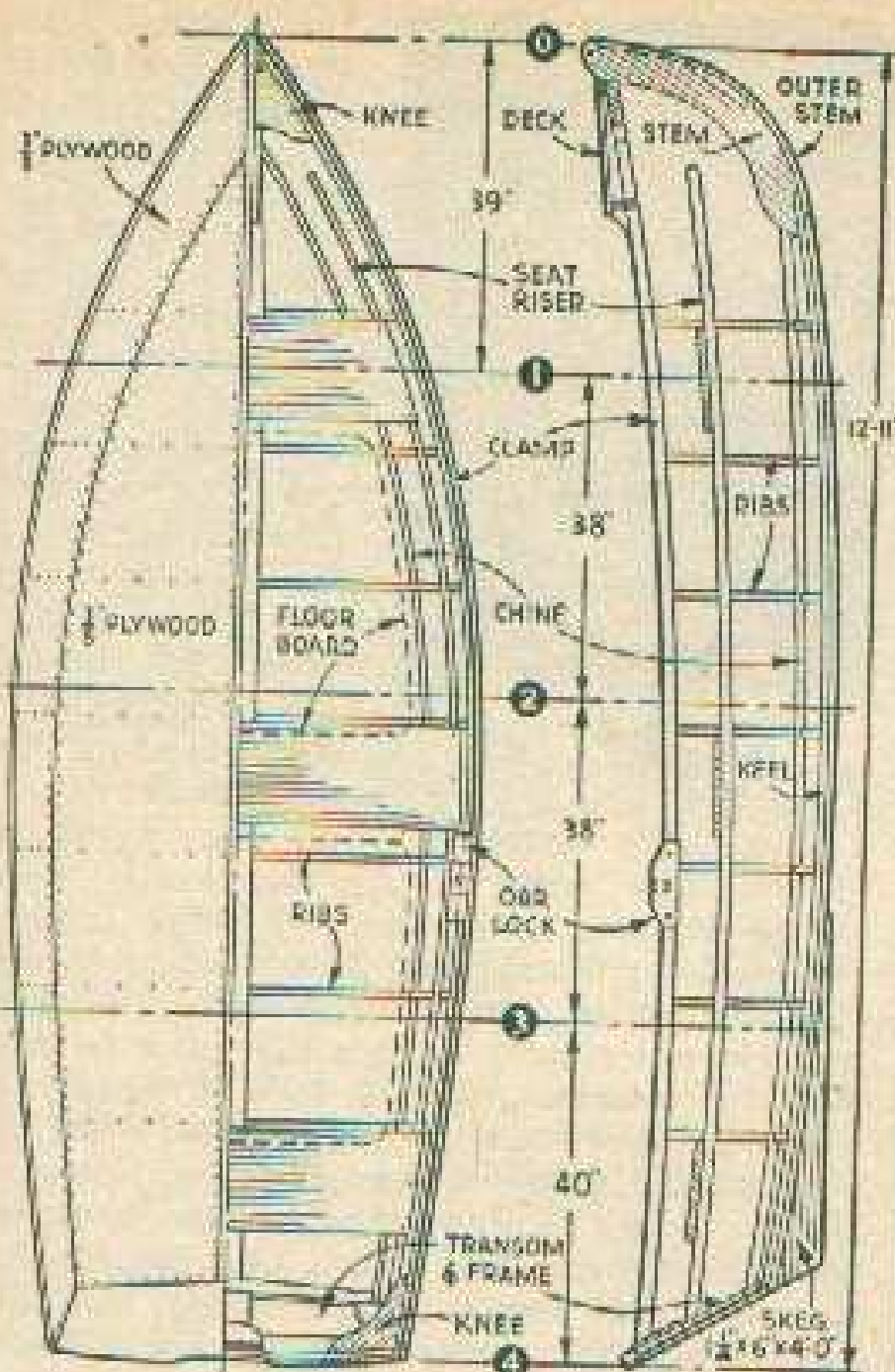


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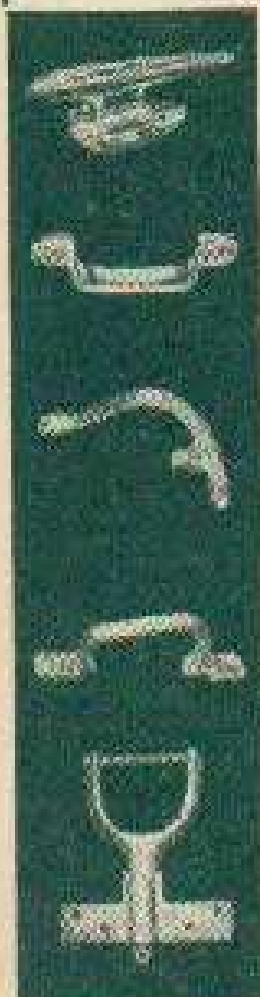
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fastened as the chines were. Then place the outer keel in position to inner keel and screw-fasten with 1 1/2 inch #8 flathead screws at 8 inch intervals.

The entire framework is now trimmed and faired at all points so planking to be applied lies evenly. The sides are planked first. Lay a sheet of plywood in position on sides, mark and saw to shape, using shaped piece as a pattern for the opposite side. Coat all adjoining surfaces with resin glue and clamp shaped side planks in position with "C" Clamps, fastening planking in place with 1 inch #8 flathead screws, spaced about 2 inches apart. Screw-fasten to chines, transom, and stem, and fasten to clamps with 1 1/4 inch galvanized shingle nails, clinched on the inside. With opposite sides planked, trim edges evenly along chines, and then place bot-

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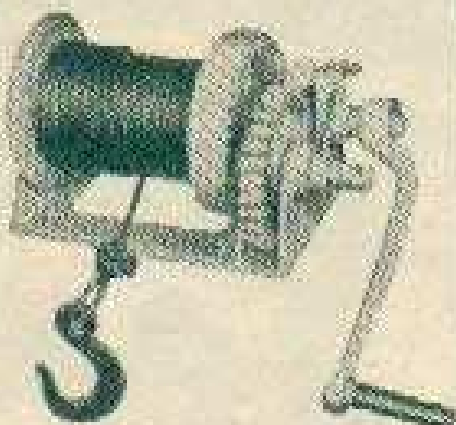
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Interior view of completed Dorette, looking aft.

tom plywood in position alongside of keel. Mark and cut it to shape, using one shaped plank as a pattern for opposite side. Before fastening bottom planking in position, coat all adjoining surfaces with resin glue and screw fasten planking to chines, keel and stem with 1 inch #8 flathead screws spaced about 2 inches apart. Use a double row of

screws along transom. When glue is dry on bottom, trim edges of planking evenly along chines, transom and stem and cover exposed edges of planking along stem with a 3/4x1 1/4 inch oak outer stem piece which is softened with hot water, bent in place and screw fastened at 8 inch intervals with 1 1/2 inch #8 screws.

The planked hull is now removed from the form, turned right side up and placed upon saw horses. Edges of plywood along the clamps are trimmed evenly. Next install the ribs; the bottom and side members are 3/4x1 1/4 inch oak pieces, and the bottom members are butted against keel and chines while the side members are butted against chines and clamps. Space ribs at 16 inch intervals, measured from transom. Coat all adjoining surfaces with resin glue and nail in position with 1 1/4 inch galvanized shingle nails inserted from outside and clinched inside. Continue until all ribs are installed and then spring the seat risers into position as indicated. Fasten them with 1 1/2 inch #10 flathead screws—one to each rib.

The 3/4x12 inch seats are next installed at positions indicated. Transom knees and breast hook are then cut to shape and screw fastened in position with 2 inch #10 flathead screws. Moldings are next clamped in position and screw fastened at 8 inch intervals with 1 1/2 inch #8 flathead screws. Trim ends of moldings nicely and, if desirable, install a short forward deck of scrap pieces of plywood as indicated. Floor boards of 1/4 inch plywood, shaped as shown are cut to shape and screw-fastened to ribs.

Coat the entire interior and exterior of the hull with a coating of Firzite and follow with three coats of paint inside and out. For a really attractive finish paint bottom green, sides white, interior buff, and varnish the seats and moldings. To complete Dorette provide oar locks as shown

• Craft Print No. 44 in enlarged size for building the "Dorette" is available at \$38 a set. Address: Craft Print, Department B-50, SCIENCE AND MECHANICS, 450 East Ohio Street, Chicago 11, Illinois.